

5/25

DART AEROSPACE LTD		Work Order:	23480
Description: Clamp		Part Number:	D1048
Drawing: D1048 Rev.A		Qty:	50 51

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	HA	05.06.06	50
2	PURCHASING	Issue P/O: 2008172 Stamp and deburr per dwg D1048 Material: Stainless steel T304#2B Supply release not for Material.	U	05.06.07	50
3	RECIEVING	Inspect for transit damage. Insure material release note is attached.	CL	05/06/30	51
4	QC	Inspect Level 6	2	05.07.05	51
5	METAL	Deburr if required. Break all sharp corners .010 / .020 as per dwg.	FF	05.07.05	51
6	METAL	Form as per dwg D2010 using DT8053	FF	05.07.14	51
7	QC	Inspect Level 5	2	05.07.18	51
8	FINISHING	Powder coat Black Sandtex (4.3.5.7) as per QSI 005	FC	05.08.09	51
9	QC	Inspect Level 3	MM	05.08.10	51
10	STORES	Bag and Tag	CL	05/08/10	51
11	EXPEDITING	Close W/O Inspect level 21 Job Cost/ Job 4.56 545 05/08/11	(51)	05/08/10	51

Rev.	Date	Change	Revised By	Approved
B	02.02.22	Re-format	NG	

RELEASED

02/02/22

UNDER REVIEW

03.10.21 RF

COMBINE INFO
DS00-560-041

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 05/08/10

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

RELEASED
97/09/02 PCW

NOTES:

1) MATERIAL

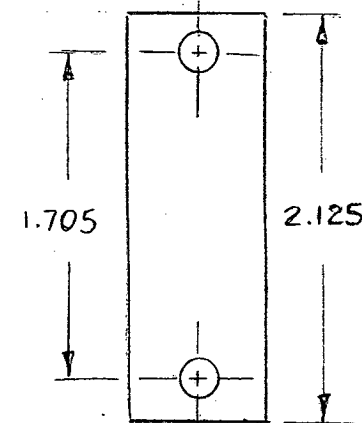
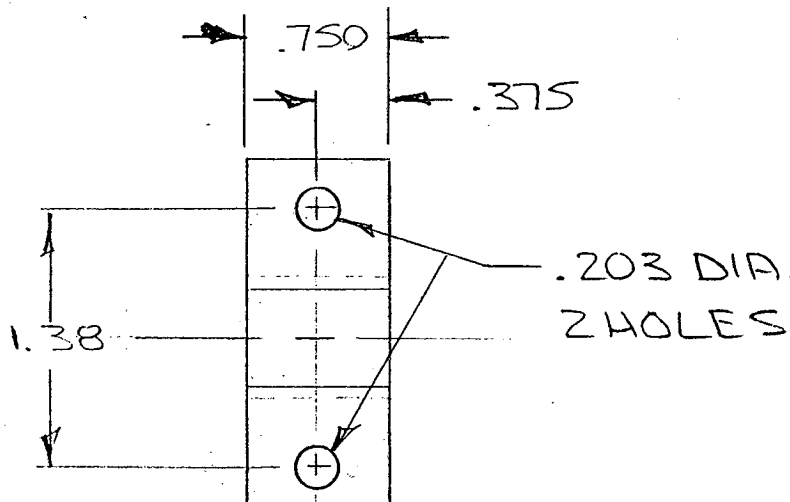
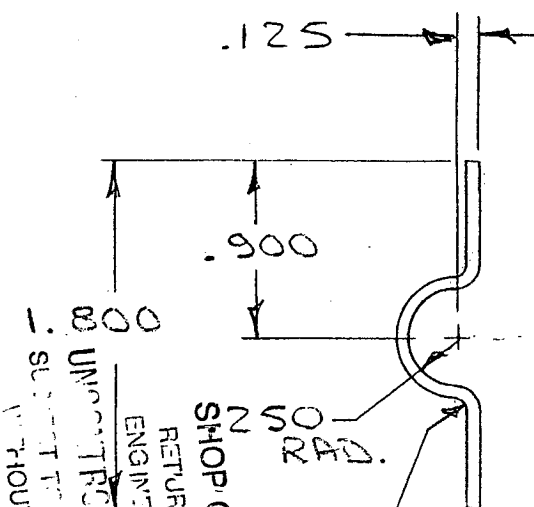
STAINLESS STEEL

T304#2B .062 THICK

2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7)

PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.010 TO 0.020



FLAT PATTERN

WORK ORDER
NO. 23480

UNCONTROLLED COPY
RETURN TO
ENGINEERING
WITHOUT NOTICE

SHOP COPY
250 RAD.
(TYP)



D1048

A

A	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR		
	RF		DRAWN	BASIC CODE	DIA. DASH NO. H=HEAD NEAR SIDE F=HEAD FAR SIDE	CONTRACT NO.		DART AERO ACCESSORIES INC. VANCOUVER CANADA			
			APPROVED	D=DOUBLE DIGIT=NO OF SHEETS C=COUNTERSINK	LENGTH DASH NO. W=SPOTWELD	DESIGN BRADLEY	DATE JUL 1 1997	TITLE CLAMP			
			DESCRIPTION OF CHANGE	BASIC CODES BJ=MS20470AD BB=MS20476AD		STRESS		CODE	DWG NO. D1048	REV. A	
01.12.05 ADD FLAT PATTERN		REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		REPORT ALL DISCREPANCIES — DO NOT SCALE							
		GENERAL		LIMITS		SCALE 1:1 SHT 1 OF 1					
		1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125/1 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER MIL - S - 7742 5. HOLES PER AND 10367		1. TOLERANCES — .XX ± .030 XXX ± .010 2. ANGLES 1 W° 3. PARALLELISM 1 .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005							

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 03, 2005
10:33 am

Work Order No : 0023480
Project Name : D1048
Project For : WK525
Work Order Type : Main
Main WO Number :
House Part Number : D1048
Description : Clamp
Manufactured : Yes
Amount Req'd : 50
Amount Done : 0
Start Date : 06-03-05
Est Finish Date : 06-24-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

90239212

INSPECTION CERTIFICATE

MATERIAL TEST/INSPECTION CERTIFICATES

 燁茂實業股份有限公司
YIEH MAU CORP.

INVOICE NO. : F03MB57
COMMODITY : PRIME COLD ROLLED STAINLESS STEEL SHEET AISI 304, NO.4 (SIC)
FINISH WITH 100 MIC.FILM ON MAIN SIDE, WITH BACK-PASS,
SLITTED EDGE AISI 304, 2B FINISH, WITH PAPER INTERLEAVED,
SLITTED EDGE.
SPECIFICATION : AISI 304
CUSTOMER : INTEGRIS METALS LTD

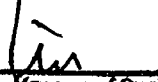

工廠:高雄縣路竹鄉順安路345號
345, SHUN AN RD. LU CHU HSIANG
KAOHSIUNG TAIWAN R.O.C.
TEL:(07)6972885 FAX:(07)6973006
CERTIFICATE NO:9212243
DATE OF ISSUE:12/31/2003

(ITEM NO) SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test GL=50 m/m					Chemical Composition (%)							
		KGS	LBS			Y.S. (N/mm ²)	T.S. (N/mm ²)	E.L. (%)	HRB	HV	C x100	Si x100	Mn x100	P x1000	S x1000	Ni x100	Cr x100	N x100
AISI 304 2B (7425-4228)																		
24GA/48"X120" (7425-8401)	1	1,442	3,179	YU129992	2AS68986C-1	281	687	56	81	157	4.6	50	110	26	4	804	1819	3.1
20GA/48"X120" (7426-2619)	1	1,446	3,188	YU226021	29S65042BA-21	293	636	58	81	157	4.4	55	115	31	4	808	1808	3.6
18GA/48"X120" (7426-5059)	1	1,428	3,148	YU226201	2AS68982B-21	303	672	56	83	165	4.2	52	115	23	2	814	1824	3.8
16GA/48"X96"	1	1,414	3,117	YU225206	2AS68037-21	301	675	55	81	158	5.5	60	106	26	3	826	1818	2.2
16GA/48"X96"	1	1,412	3,113	YU225206	2AS68037-22	301	675	55	81	158	5.5	60	106	26	3	826	1818	2.2
16GA/48"X96" (7426-5166)	1	1,413	3,115	YU225206	2AS68037-23	301	675	55	81	158	5.5	60	106	26	3	826	1818	2.2
16GA/48"X120"	1	1,385	3,053	YU225390	2AS67026B-1	306	694	50	83	163	5	52	104	23	4	806	1816	2.7
16GA/48"X120"	1	1,385	3,053	YU225390	2AS67026B-2	306	694	50	83	163	5	52	104	23	4	806	1816	2.7
16GA/48"X120" (7426-5455)	1	1,215	2,679	YU225390	2AS67026B-3	306	694	50	83	163	5	52	104	23	4	806	1816	2.7
16GA/60"X96" (7426-5497)	1	1,438	3,170	YU226508	2BS69861A-23	306	687	52	82	160	3.8	50	109	29	6	808	1809	2.6
16GA/60"X120" (7426-5612)	1	1,411	3,111	YU226508	2BS69861A-22	306	687	52	82	160	3.8	50	109	29	6	808	1809	2.6
16GA/60"X144" (7426-7949)	1	1,434	3,161	YU226508	2BS69861A-21	306	687	52	82	160	3.8	50	109	29	6	808	1809	2.6
14GA/48"X96"	1	1,432	3,157	YU130016	2AS68134B-2	304	640	50	83	163	4.8	52	112	26	4	812	1816	2.8
14GA/48"X96" (7426-8053)	1	1,432	3,157	YU130016	2AS68134B-3	304	640	50	83	163	4.8	52	112	26	4	812	1816	2.8
14GA/48"X120"	1	1,435	3,164	YU225138	2AS68038B-1	303	661	50	83	163	4.6	45	104	22	8	812	1805	2.6
14GA/48"X120"	1	1,437	3,168	YU225138	2AS68038B-2	303	661	50	83	163	4.6	45	104	22	8	812	1805	2.6
14GA/48"X120" (7426-8160)	1	1,437	3,168	YU225138	2AS68038B-3	303	661	50	83	163	4.6	45	104	22	8	812	1805	2.6
14GA/48"X144" (7426-8244)	1	1,425	3,142	YU130016	2AS68134B-1	304	640	50	83	163	4.8	52	112	26	4	812	1816	2.8
14GA/60"X96"	1	1,413	3,115	YU130125	2AS69265A-6	299	656	54	83	162	5	47	111	27	2	810	1808	3.6
19		26,834	59,158															

Remarks: NO MERCURY CONTAMINATION
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE CONTRACT.

Bend test: good for all Heat NO.
PRODUCT IN ACCORDANCE WITH ASTM A240, A480,
A262E, ASME SA240, QQS766D.

YIEH MAU CORP.

 
Manager of Quality Assurance Services

16ga 304 2B SS